Qty:

2 Um:

Each

Friday, 25/07/2008 4:20:54 PM

Julie Lecoca

User

**Process Sheet** 

**Drawing Name** 

Part Number

Material

Due Date

**Drawing Number** 

**Project Number** 

**Drawing Revision** 

: BRACKET

: D21962

: N/A

: C

. D2196 REV C

: 20/08/2008

Customer

: CU-DAR001 Dart Helicopters Services

Type

Job Number **Estimate Number** 

S.O. No. :

: 40764 : 13511

P.O. Number

: 25/07/2008 This Issue

: NC

: // First Issue

**Previous Run** 

Prsht Rev.

Written By

Checked & Approved By

08-07-24 new issue ec verified by:dd

: SMALL /MED FAB

Comment : Est Rev:A

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description: 304/316 Sheet .063

M304S16GA 1.0

Comment: Qty.:

0.2216 sf(s)/Unit Total: 304 SS Sheet 0.063" thick

0.4431 sf(s)

batch: 168 724

2.0

FLOW WATER JET



**Comment: FLOW WATER JET** 

1-Cut as per Dwg D2196

Dwg Rev: Prog Rev: B8-8-91

2-Deburr if necessary

1B 8-8-21

3.0

INSPECT PARTS AS THEY COME OFF MACHINE



FB 8-8-21

4.0

QC8

Comment: INSPECT PARTS AS THEY COME OFF MACHINE



Comment: SECOND CHECK

5.0

NC BRAKE

SECOND CHECK

BRAKE NC

Comment: NC BRAKE

Bend as per dwg D2196



Dart Aerospa	ce	Ltd
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W/O:			WORK ORDER O	CHANGES				
DATE	STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng /ı Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Category:	NCR: Yes	No DQ	A:	Date:	
		``	1	QA:	N/C Close	d:	Date:	

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE STEP	Description of NC		Corrective Action Section B					
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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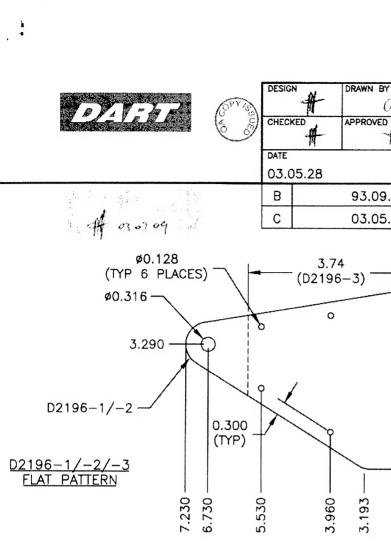
NOTE: Date & initial all entries

Friday, 25/07/2008 4:20:54 PM Date: User: Julie Lecocq **Process Sheet** Drawing Name: BRACKET Customer: CU-DAR001 Dart Helicopters Services Job Number: 40764 Part Number: D21962 Job Number: Seq. #: **Machine Or Operation:** Description: QC5 INSPECT WORK TO CURRENT STEP 6.0 Comment: INSPECT WORK TO CURRENT STEP PACKAGING 1 PACKAGING RESOURCE #1 7.0 Identify wiith Dart part # using a fine point permanent marker and Stock Location: W 08,08,24 8.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion

## **Dart Aerospace Ltd**

W/O:	, , , , , , , , ,	1 · · · · · · · · · · · · · · · · · · ·	WORK ORDER CHAI	NGES		Ī	
DATE	STEP	PROC	EDURE CHANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	_ Fault Category:	NCR: Yes N	lo DQA:	Date:	
			·	QA: N/0	C Closed:	_ Date:	
NCR:	- (1)	W	ORK ORDER NON-CONFOR	MANCE (NCR)			
		Description of NC	Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng	on Sign & Date	Section C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries



W HAWKESBURY, ONTARIO, CANADA APPROVED DRAWING NO. REV. C D2196 SHEET 1 OF 1 TITLE SCALE **BRACKET** 1:2 93.09.23 REDESIGN 03.05.28 REDRAW; D2196-3 NOW 0.5" THICK 000 - RO.50 (TYP ALL CORNERS) -4.000- 3.625 - 3.000 2.688 Ø0.203 (TYP 5 PLACES) -1.7500.813 0.375 0.500 O 0.000 .390 375 0.000 da D2196-1 D2196-2 BRACKET D2196-1/-2BRACKET 1) MATERIAL: AISI 304/316 S.S. 0.064" THICK (M304S16GA) D2196 - 3**SPACER** D2196-3 **(**) **(**) 2) MATERIAL: 5052H32 (QQ-A-250/8) 0.500" THICK 4x0.125 THICK 3) FINISH: CHEMICAL CONVERSION COAT MS20470AD4-14 5.34 RIVET PER DART QSI 005 4.1 (6 PLACES) 0 D2196 BRACKET (ASSEMBLY): 4) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 0 GENERAL NOTES: <u>\$ΗΘ</u>ΡΈΦΡΥ 5) ALL DIMENSIONS ARE IN RETURN TO **INCHES** 2.00 --- R0.063 **ENGINEERING** 6) TOLERANCES ARE PER UNCONTROLLED COPY DART QSI 018 UNLESS SUBJECT TO AMENDMENT D2196 BRACKET OTHERWISE NOTED WITHOUT NOTICE 7) BREAK ALL SHARP EDGES 0.005 TO 0.015 (ASSEMBLY) WORK ORDER

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-DART-AEROSPACE LTD	₩ork Order: 407	64
Description: BRACKET	Part Number: Dal	96-2
Inspection Dwg: 1) 2(46-7) Rev: C	P	age 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
861, 🔯	1005-2001	1131	*			
0 ,703	+ 005 - 001	1904	*			
0 316	t.006001	317	×			
375	14- 010	375	R			
. 813 -	1-1	,814	*			<u> </u>
1.750	1/2 .010	(.752	×			
3,688	400	832.6	2			
3.675	4010	3,630	Ø			·
4.000	1/ .010	4.006	¥			
,375	1 .010	1375	X			
1.700	4010	1.203	×			
2.390	7010	2.393	×			
3960	700	3,962	*			
082.2	510. 1	5.530	×			
6.730	1-/010	6.730	× .			
7,230	4- 00	7,229	*			
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Measured by:	B	Audited by:	5.	Prototype Approval:	1	Γ.
Date:	8-8-21	Date:	08/00/21	Date:		6
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Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	

